

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD		ECN #: 712	
Date: 05.07.22		Created By: RF	Checked By: RF
Project No: D412-724		Approved By: RF	Approved By: (Management if reqd) N/A
Project Name: HEAD REST			
Description of Change: RELEASE: D3304 REV. B			

Notification/Acceptance	Affected	Initials	Authorization
QA	✓	RF	OK per RF
Production	✓	RF	
Planning	✓	RF	
Marketing	N/A	RF	

Engineering Actions	Yes	No	Responsible	To happen by:	Complete
Update Blue/Pink File		✓			
Update DSI File		✓			
Update D-Part Master Binder	✓		KJ	ASAP	05.08.19 RF
Update Grey Project Binder		✓			
Update DEO Binder		✓			
Update Master Document List		✓			
Update Drawing Approval Record	✓		KJ	ASAP	05.08.11 RF
Update Change Record Form		✓			
Move Electronic File	✓		KJ	ASAP	05.08.19 RF
Notify TCA of Change	✓		DS	ASAP	05.08.11 RF
Notify FAA of Change		✓			
Update QSI 021		✓			
Update QSI 036		✓			
Scan Documents		✓			
Update MIS Database	✓		KJ	ASAP	05.08.19 RF
Update Access Database	✓		KJ	ASAP	05.08.19 RF
Verification ARC		✓			
Create/Update STC Approval List		✓			
Create/Update IPP's	✓		JLM	ASAP	05.08.19 RF
Create/Update BOM's	✓		JLM	ASAP	05.08.19 RF
Create/Update PPP's		✓			
Update Paperwork Kits in Production		✓			
Update Paperwork Kits in Stock		✓			
Rework/Scrap Current Production		✓			
Rework/Scrap Kits in Stock?		✓			
Create/Update Laminated Dwgs		✓			
Create/Update Controlled Dwgs	✓		KJ	ASAP	05.08.19 RF
Create/Update FAI sheets		✓			
Create/Update CNC Programs		✓			
Create/Update Tooling	✓		DAN	ASAP	N/A RF 05.09.12
Create/Update DXF File	✓		RF	ASAP	05.07.22
MPP required?		✓			
Notify Previous Customers		✓			
Notify Eurocopter France		✓			

Notes:
 - ENSURE WELDING TOOL WORK PROPERLY AS PER REV. B
 - CREATE IPP'S & BOM FOR D3304-7/-8 done
 - UPDATE IPP'S & BOM FOR D3304-043/-044 AS PER REV. B. done
 - DXF ALREADY IN DXF FILE.
 - TOOLING IS NOT REQ'D, BECAUSE NOW IS D3304-7/-8 BRACKET ~~RF~~ 05.09.12

DART AEROSPACE LTD		Work Order:	
Description: Tube Assembly		Part Number:	D3304-043
Dwg: D3304 Rev. A1		Qty:	
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler																			
2	MC	Cut blank: 22.00" as per Dwg D3304 Material: AISI 304/316 SS tubing 0.875" x 0.065" wall (M304TR0.875W.065) Identify for D3304-3 Batch: _____																			
3	MC	Turn as per Folio FA458 and Dwg D3304 Identify as D3304-3																			
4	QC2	Inspect parts as they come off the CNC machine																			
5	QC8	Second check																			
6	MC	Deburr																			
7	GA	Form as per Dwg D3304 Ensure that bend radius does not fall into straight section using DT8756.																			
8	GA	Drill as per Dwg D3304 using drill Jig D3304-T1																			
9	GA	Cut tube to length as per Dwg D3304																			
10A	GA	Deburr																			
10B	QC5	INSPECT WORK TO STEP 10A																			
11	WS	Weld bracket as per Dwg D3304 and QSI 004 using DT8775 Pick: <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>1</td><td>D3304-3</td><td>Bracket</td><td></td></tr></table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	1	D3304-3	Bracket												
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																		
1	D3304-3	Bracket																			
12	QC9	Inspect weld																			
13	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3																			
14	QC3	Inspect Powder Coat																			
15	GA	Assemble lanyard and pip pin as per Dwg D3304 Pick: <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>1</td><td>BLBS-0016</td><td>Pip Pin</td><td></td></tr><tr><td>2</td><td>CBL-460</td><td>Loop Sleeve</td><td></td></tr><tr><td>12.5"</td><td>CBL-1240</td><td>Cable</td><td></td></tr></table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	1	BLBS-0016	Pip Pin		2	CBL-460	Loop Sleeve		12.5"	CBL-1240	Cable				
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																		
1	BLBS-0016	Pip Pin																			
2	CBL-460	Loop Sleeve																			
12.5"	CBL-1240	Cable																			
16	QC5	Inspect work to Step 15																			
17	ST	Identify parts with batch number and part number using a fine point permanent marker as per Dwg D3304 and Stock																			
18	AC	Cost / part: _____																			
19	DC	Close W/O Inspect Level 21																			

Rev	Date	Change	Revised By	Approved
A	04.09.08	New issue	KJ/JLM	
B	04.09.28	BLBS-0016 changed from BLRS-001	KJ/JLM	
C	04.11.17	Revised Step 15	KJ/JLM	
D	04.11.26	Revised Steps 7	KJ/JLM	

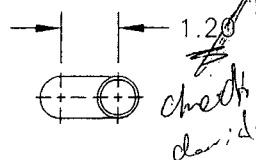
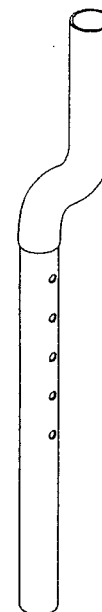
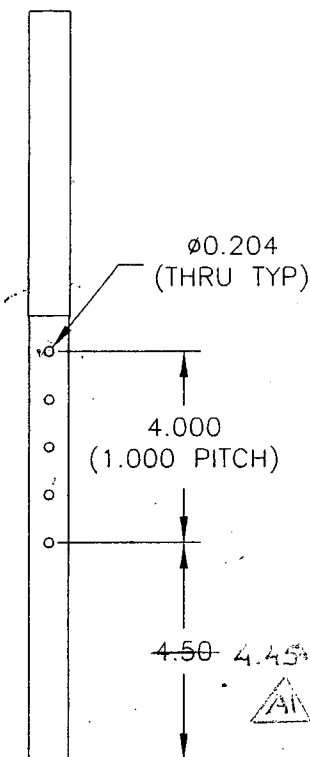
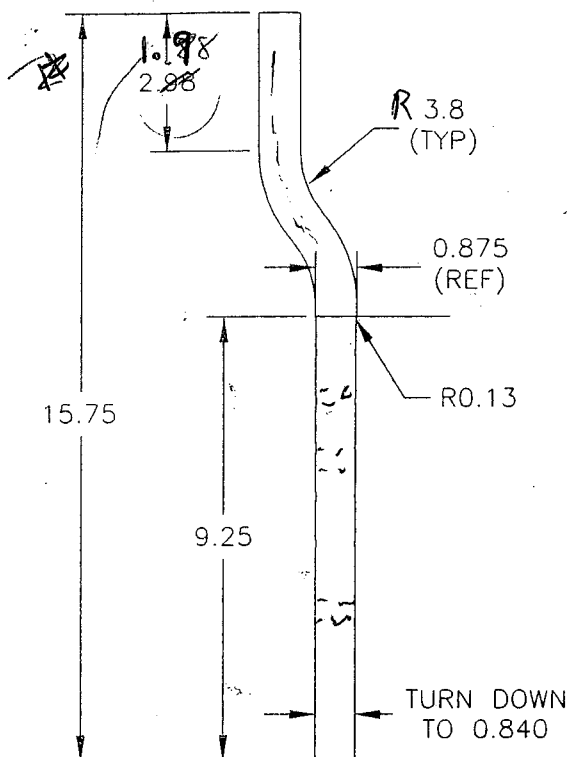
RELEASED
04/11/28

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. A SHEET 3 OF 4
DATE 04.08.18	TITLE TUBE ASSEMBLY		SCALE 1:4

RELEASED
04.09.29 LP



Benelinos
9 5/8, 13 3/8
Total length 16 1/8
D3304-3 TUBE
REFERENCE ONLY

D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TRO.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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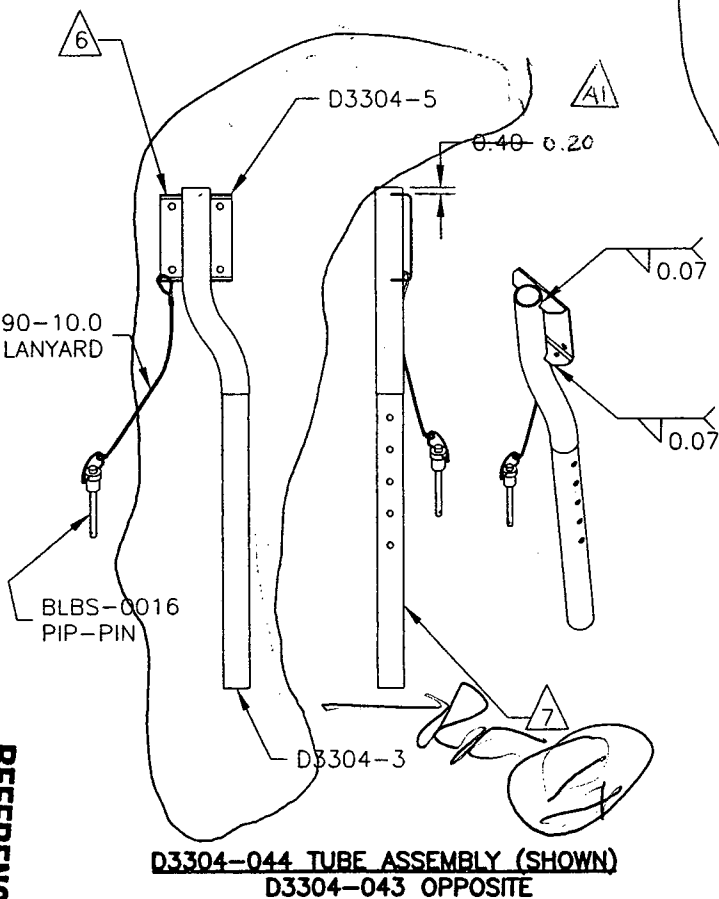
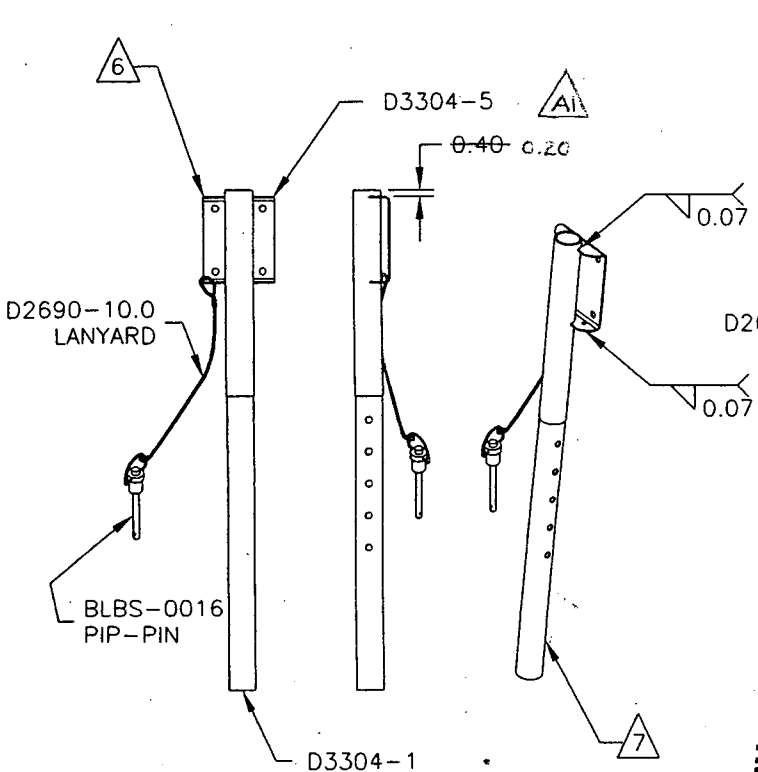
2/21 Ntges / lotar

8/31, 8/30

2011 / 1002

DART**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DESIGN	RF	DRAWN BY	RF	DRAWING NO.	REV. A
CHECKED		APPROVED		D3304	SHEET 1 OF 4
DATE	04.08.18	TITLE	TUBE ASSEMBLY	SCALE	1:6
A	04.08.18	NEW ISSUE			
A1	04.11.23	0.20 WAS 0.40; 4.45 WAS 4.50			

Handwritten: PDA4-11**UNDER REVIEW**05.06.09
CHECK WITH
ROBERTO**D3304-044 TUBE ASSEMBLY (SHOWN)**
D3304-043 OPPOSITE**D3304-041 TUBE ASSEMBLY****REFERENCE ONLY****D3304-041/-043/-044 NOTES:**

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRC ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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Linda Lacelle

From: "Roberto Fuentes" <robertof@dartaero.com>
To: "Linda Lacelle" <lindal@dartaero.com>
Sent: Monday, June 13, 2005 3:48 PM
Subject: Re: p codes

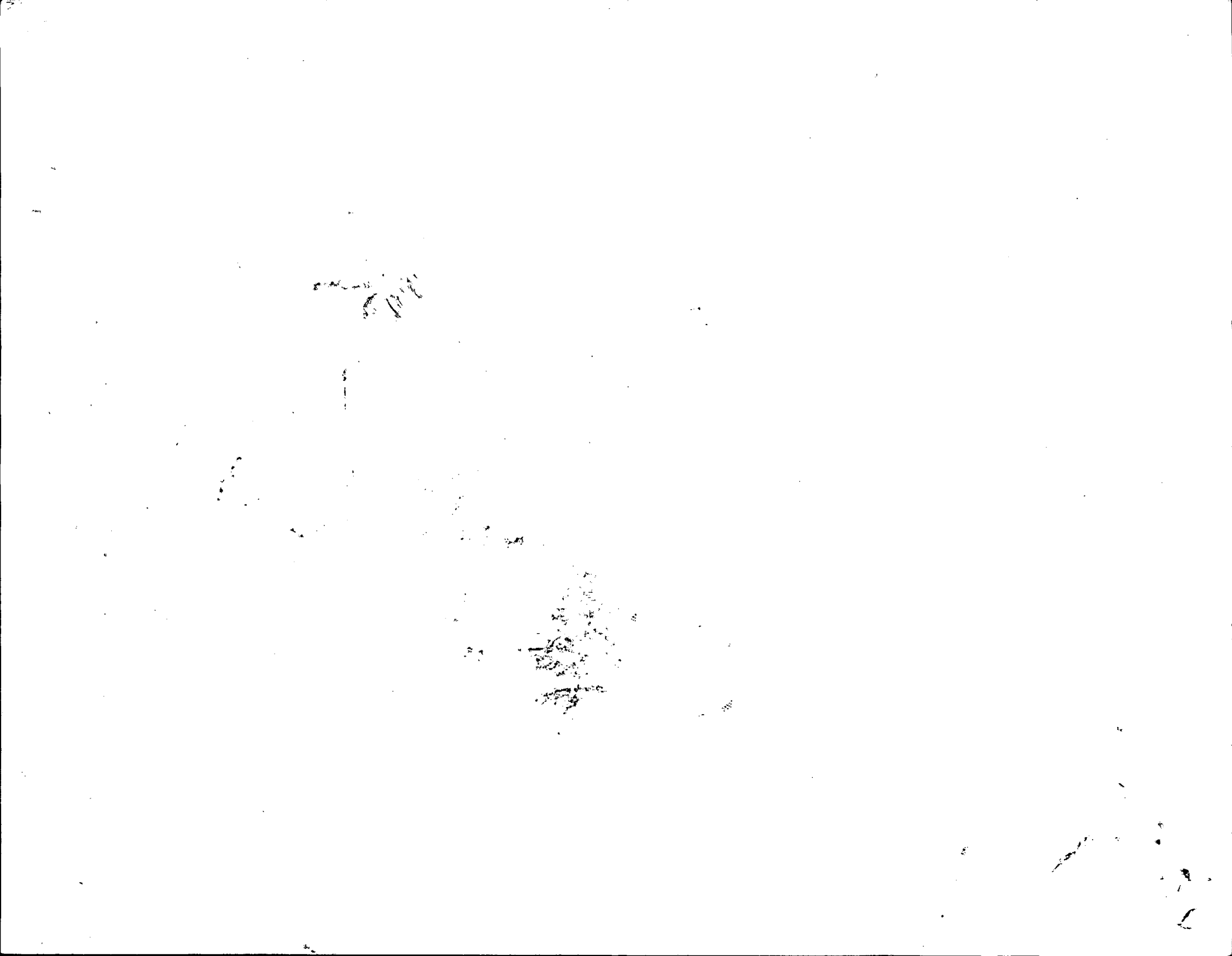
Eurocopter GHW Mod. P601-600
Tube Headrest P604-561

----- Original Message -----

From: Linda Lacelle
To: *Roberto Fuentes
Sent: Monday, June 13, 2005 2:47 PM
Subject: p codes

Roberto,
Do you have P codes for the D2281 jack saddle (grd handling - eurocopter)
and D3304 tube assembly(headrest)?
Linda

6/13/2005

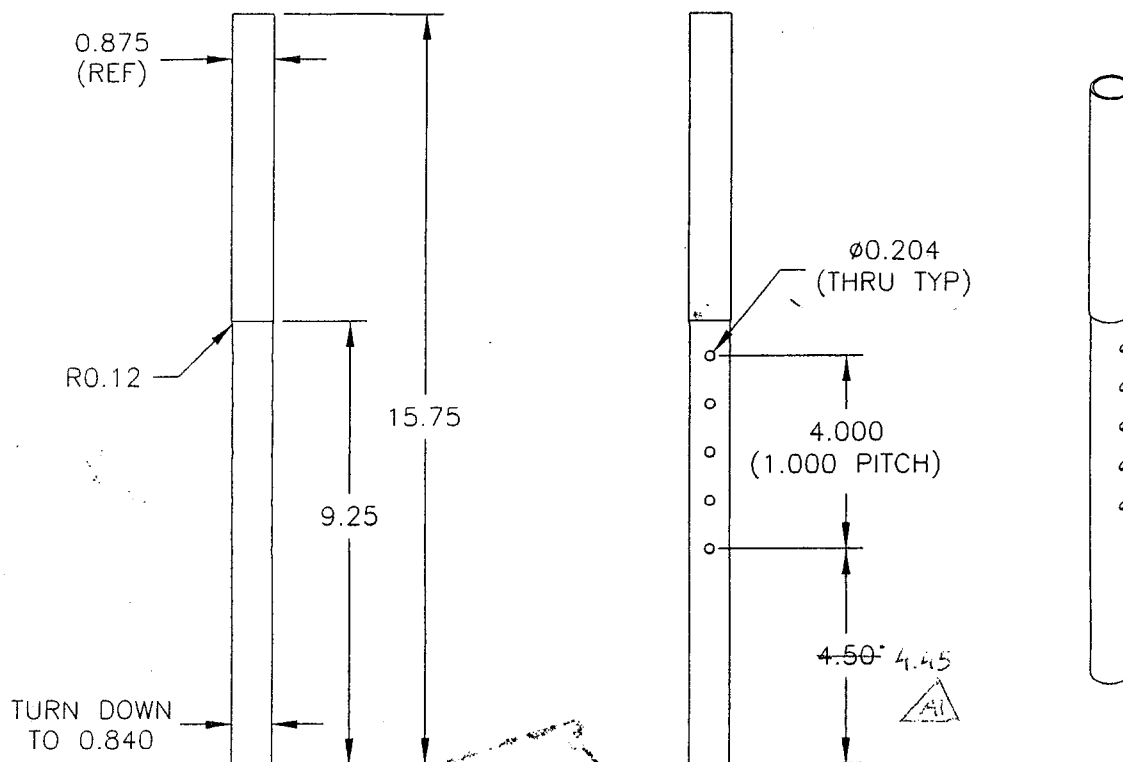


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DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3304	REV. A SHEET 2 OF 4
DATE 04.08.18		TITLE TUBE ASSEMBLY	SCALE 1:4

RELEASED
04.09.25



02851W

REFERENCE ONLY

D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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